

Work Order ID 92463

October-30-12 8:48:12 AM

92463

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2

Start Date: 30/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-10-30 Tooling:

Date: _____

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2750 | F |
| D3492 | C |

100

100

DOCUMENT CONTROL

5L 0.00 DAS 15 10/11/26

DC

Document Control

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

J for MLJ 12-11-23

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--|------|--|--|--|--|------------------------------------|--------------------------------------|--------------|--------------|
| Part No. _____ | | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | |
| NCR No. _____ | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | | | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | |
| | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | | | |
| | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | | | | | |
| | | | | <input type="checkbox"/> Other | | | | | |

Work Order ID 92463

October-30-12 8:48:12 AM

92463

Page 2

Item ID: D350-636-012

Accept

N900040100

Setup

Start

NS1**Revision ID:****Item Name:** Skidtube RH

Stop

NS2**Start Date:** 30/10/2012 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 13/11/2012 **Req'd Qty:** 1.00***1*****Customer:****Reference:**

| | | | | | | | |
|-------------------|----------------------|--------------|-----------------|--------------|------------|--------------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | | | | | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|------------------------------|----------------|---------------|----------------------|-----------------------|-----------------------|--------------------------|------------------------|
| 110 | | 0.00 | | | | | | | |
| *110* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1- Pick D2600-3 Bent | | | | | | | | |
| | 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750 | | | | | | | | |
| | 3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr. | | | | | | | | |
| | 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting | | | | | | | | |
| | 5- Drill only two fwd step holes using DT9616. Ensure proper positioning. | | | | | | | | |
| | 6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) | | | | | | | | |
| | 7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE*** | | | | | | | | |
| | 8-Open up holes for Detail "K" to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail L to 0.500" (8 holes per side) | | | | | | | | |
| | 9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". | | | | | | | | |
| | 10-Open up holes of Detail A to 0.297" (total of 2 holes per side) | | | | | | | | |

12/11/08

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|------|--|--|--|--|--------------------------------------|-------------|--------------|--------------|--|
| Part No. _____ | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| NCR No. _____ | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | |
| | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | |
| | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other | | | | | | |
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Work Order ID 92463

October-30-12 8:48:12 AM

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Page 3

Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2Start Date: 30/10/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 13/11/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---|-------------------|--------------|---------------|---------------|------------------|----------------|
| 120 | 11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: <i>M122357</i> | 3 | <i>3</i> | <i>BL12-11-08</i> | | | | | |
| | 12-Grind welds flush as per Dwg D2750 | | | | | | | | |
| 120 | QC10- Inspect visual per QSI004- ground welds | 0.00 |  | 12.11.8 | | | | | |
| | Memo | 0.00 | | | | | | | |
| 130 | QC5- Inspect part completeness to step on W/O | 0.00 |  | 12.11.8 | | | | | |
| | Memo | 0.00 | | | | | | | |

120

QC

Quality Control

130

QC

Quality Control

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
|--|------|------------------------------------|--|--|------------------------------------|--|--------------------------------------|-------------|--------------|--------------|
| Part No. _____ | | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| NCR No. _____ | | Use-as-is <input type="checkbox"/> | Work Order Update <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | | | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | | | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | |
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NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|------|--|--|--|--|--------------------------------------|-------------|--------------|--------------|
| Part No. _____ | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| NCR No. _____ | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | |
| | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other | | | | | |
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Work Order ID 92463

October-30-12 8:48:12 AM

92463

Page 5

Item ID: D350-636-012

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2Start Date: 30/10/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 13/11/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|------|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | Stop | | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | | 0.00 | | | | | | | |
| *160* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. | | | | | | | | |
| | 2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750. | | | | | | | | |
| | 3-Open float holes to .500" (4 per Side) | | | | | | | | |
| | 4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) | | | | | | | | |
| | 5-Deburr and blow out all chips from inside of tube | | | | | | | | |
| | 6-Prepare tube for welding, remove alodine as required. | | | | | | | | |
| | 7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>3123353</u> exp. date: <u>13-06-22</u> | | | | | | | | |
| | 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) | | | | | | | | |
| | 9- At section AP-AP drill out x-bolt spacer to 0.404" | | | | | | | | |
| | 10-Grind welds flush as per Dwg D2750 | | | | | | | | |
| | 11-Spot face ground handling holes section (total of 4 places per side) as per | | | | | | | | |

8/12-11-13

> DP 12-11-15

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
|--|--|------|------|---|--|--|--|---|--|-------------|--------------|--|--|---|--|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | |
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| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
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Work Order ID 92463

October-30-12 8:48:12 AM

Item ID: D350-636-012

Accept

92463***N900040100***

Setup

Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2Start Date: 30/10/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 13/11/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

dwg.D2750

12-Deburr holes

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

170

QC

Quality Control

Memo

0.00
(DAS
16
8-09)

12-11-15

0.00
(DAS
16
8-09)

Rhu15

180

QC5- Inspect part completeness to step on W/O

180

QC

Quality Control

Memo

VERIFY C'BOARD IS GOOD

0.00
(DAS
16
8-09)

Rhu15

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
|--|--|------|------|---|--|--|--|---|--|-------------|--------------|--|--|---|--|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |
| | | | | | | | | | | | | | | <input type="checkbox"/> Other | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
|--|------|------|--|---|------------------------------------|--|--------------------------------------|---|-------------|--------------|--------------|--|--|---|--|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|------|--|--|---|--|--------------------------------------|--|-------------|--------------|--------------|--|
| Part No. _____ | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | |
| NCR No. _____ | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | |
| | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | |
| | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | | | | |
| | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | | |
| | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | | | | | |
| | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | | | | | | | |
| | | | | <input type="checkbox"/> Other | | | | | | | |

Work Order ID 92463

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92463

Page 9

Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1**Revision ID:****Item Name:** Skidtube RH

Stop

NS2**Start Date:** 30/10/2012 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 13/11/2012 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

240

QC5- Inspect part completeness to step on W/O

0.00

DAS
15
8-89

10/11/20

J

240

QC

Quality Control

250

Pick Kit

0.00

DAS
15
8-89

10/11/20

250

Packaging

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

DAS
15
8-89

10/11/26

J

260

QC

Quality Control

DAS
20
8-89

12/11/23 JF

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--|------|------|-----|---|--|---|--|--|-------------|---|--------------|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Work Order ID 92463

October-30-12 8:48:12 AM

92463

Page 10

Item ID: D350-636-012

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2

Start Date: 30/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|-------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------|---------------------------------|----------------------|----------------|--------|--------------|---------------|---------------|------------------|----------------|
| 270 *270* Packaging | Packaging | 0.00 | <i>Raw I</i> | | | | | | |
| | Memo | 0.00 | <i>Loc 072</i> | | | | | | |
| Packaging | Package as per PPP D350-636-012 | | | | | | | | |

| | | | |
|---------------------------|---|------|------------------------------|
| 280 *280* QC | QC21- Final Inspection - Work Order Release | 0.00 | <i>12/11/2012</i> |
| Quality Control | Memo | 0.00 | <i>MF</i> <i>12-11-26</i> |

NCR: Yes / No

DQA: Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | |
|--|------|------|-----|---|--|---|--|--|-------------|--------------|--------------|--|---|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled |

Picklist Print

Page 1

October-30-12 8:48:15 AM

Work Order ID: 92463

92463
D350-636-012

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:I02.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-3-BENT | | Manufactured | No | | | 110 | Each | 35.0000 | 1 | 1 | | | ** |

D2600-3-BFNT

Extrusion Bent

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 35 | |
| 66875 | 7 | |
| 73253 | 1 | |
| 75021 | 1 | |
| 75022 | 1 | |
| 75023 | 1 | |
| 81330 | 4 | |
| 83305 | 1 | |
| 92049 | 19 | |

D2744

Manufactured No

110 Each 51.0000

1 1

**

D2744

Cap

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG002 | 51 | |
| 62715 | 1 | |
| 85506 | 22 | |
| 91307 | 28 | |

BL12-11-08

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: Part No. NCR No. | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | | | | |
|---|------|---|---|---|--|---------------------------------|-------------|--------------|--------------|---|--|--|--|--|--|---|--|
| | | Rework Scrap Use-as-is Work Order Update | Skid-tube Machining Thermoforming Large Fab | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | Engineering Quality Other | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | |
| Landing Gear | | | General | | | | | | | | | | | | | | |
| <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Picklist Print

Page 2

October-30-12 8:48:15 AM

Work Order ID: 92463

92463
D350-636-012

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

D2739

Manufactured No

160

Each

7.0000

1

1

**

D2739

350 I Beam

BE12-11-13
B 92571 x1

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| LG | 7 | |
| 72155 | 1 | |
| 81508 | 1 | |
| 85487 | 1 | |
| 87734 | 1 | |
| 91729 | 3 | |

D2743

Manufactured No

160

Each

163.0000

8

**

D2743

Crossbolt Spacer

BE12-11-14

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| LG | 89 | |
| 81965 | 23 | |
| 83262 | 2 | |
| 85459 | 4 | |
| 88504 | 60 | |
| LG001 | 74 | |
| 67766 | 4 | |
| 68251 | 3 | |
| 73403 | 64 | |
| 74445 | 1 | |
| 79517 | 2 | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|------------------------------|--|--|---|--|--------------------------------------|-------------|--------------|--------------|
| Part No. _____ | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| NCR No. _____ | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | |
| Landing Gear | General | | | | | | | | |
| | Bending | Bend | Grain | Ovalized | Pressure/Forced | | | | |
| | Centre Not Concentric to O/S | BOM/Route | Hardware | Over/Under tolerance | Temperature/Cure | | | | |
| | Cracks | Broken/Damaged | Inspection Incomplete | Part Incorrect | Weld | | | | |
| | Crushed/Crimped | Burrs | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Stock Pulled | | | | |
| | Cuffs | Contamination | Maintenance | Part Moved | | | | | |
| | Heat Treat | Countersink | Mislabeled | Positioned Wrong | | | | | |
| | Inspection Strip in Tube | Cut Too Short | Misread | Power Loss/Surge | Other | | | | |
| | Ripples in Bend | Drill Holes | Offset | | | | | | |
| | Torque Waves in Extrusion | Drawing | Out of Calibration | | | | | | |
| | Turning Sequence | Finish | Out of Sequence | | | | | | |
| | Wave/Twist in Tube | Folio | Outside Dimensions | | | | | | |

Picklist Print

October-30-12 8:48:15 AM

Page 3

Work Order ID: 92463

92463

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured

No

160

Each

46.0000

4

4

**

D3490-3

Cross Bolt Spacer

BE 12-11-14

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 40 | |
| 90352 | 40 | 4 |
| LG001 | 6 | |
| 86980 | 6 | |

D3490-1

Manufactured

No

160

Each

57.0000

4

4

**

D3490-1

Cross Bolt Spacer

BE 12-11-14

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 48 | |
| 81976 | 2 | |
| 86979 | 24 | 4 |
| 88617 | 22 | |
| LG001 | 9 | |
| 62450 | 2 | |
| 74875 | 4 | |
| 77042 | 3 | |

D3631-1

Manufactured

No

230

Each

123.0000

8

8

**

D3631-1

Washer

SL 111121

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FG | 20 | |
| 81874 | 2 | |
| 83588 | 18 | |
| FP-A | 88 | |
| 91606 | 88 | |
| ST072 | 15 | X 8 |
| 68062 | 2 | |
| 75548 | 13 | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
|---|------|------|-----|---|---------------|----------------------------|---|-------------|--------------|--------------|--|--|
| | | | | Rework | Skid-tube | Crosstube | Water Jet | Engineering | | | | |
| | | | | Scrap | Machining | Small Fab | Prod. Eng. Coor. | Quality | | | | |
| | | | | Use-as-is | Thermoforming | Finishing | Rec/Store/Packaging | Other | | | | |
| | | | | Work Order Update | Large Fab | Composite | Supplier | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other | |
| | | | | | | | | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |

Picklist Print

Page 4

October-30-12 8:48:15 AM

Work Order ID: 92463

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

92463
D350-636-012

Start Date: 30/10/2012

Start Qty: 1.00

Required Date: 13/11/2012

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

10.0000

1

1

**

M

u11121

D3791-1

Wearplate

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-------|---|--------|
| FP001 | 7 | B91899 |
|-------|---|--------|

89244

7

X1

| | | |
|-------|---|--|
| FP002 | 3 | |
|-------|---|--|

62239

2

| | | |
|-------|---|--|
| 83392 | 1 | |
|-------|---|--|

D3793-3

Manufactured No

230

Each

17.0000

1

1

**

M

u11121

D3793-3

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-------|----|--|
| FP001 | 17 | |
|-------|----|--|

87135

5

| | | |
|-------|----|--|
| 91326 | 12 | |
|-------|----|--|

X1

MS21043-6

Purchased No

230

Each

408.0000

4

**

M

u11121

MS21043-6

NUT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|----|----|--|
| FG | 20 | |
|----|----|--|

103693

20

| | | |
|-------|-----|--|
| ST301 | 388 | |
|-------|-----|--|

117887

4

| | | |
|--------|-----|--|
| 120308 | 384 | |
|--------|-----|--|

X4

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
|------------------------------|--|----------------|------|---------------------------------|---|----------------------------|-------------------|--------------------|--|---------------------|--------------|--------------|
| | | | | Rework | | Skid-tube | | Crosstube | | Water Jet | | Engineering |
| | | | | Scrap | | Machining | | Small Fab | | Prod. Eng. Coor. | | Quality |
| | | | | Use-as-is | | Thermoforming | | Finishing | | Rec/Store/Packaging | | Other |
| | | | | Work Order Update | | Large Fab | | Composite | | Supplier | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | | |
| Bending | | Bend | | Grain | | Ovalized | | Pressure/Forced | | Temperature/Cure | | |
| Centre Not Concentric to O/S | | BOM/Route | | Hardware | | Over/Under tolerance | | Weld | | Wrong Stock Pulled | | |
| Cracks | | Broken/Damaged | | Inspection Incomplete | | Part Incorrect | | | | | | |
| Crushed/Crimped | | Burrs | | Instructions Incomplete/Unclear | | Part Lost/Missing | | | | | | |
| Cuffs | | Contamination | | Maintenance | | Part Moved | | | | | | |
| Heat Treat | | Countersink | | Mislabeled | | Positioned Wrong | | | | | | |
| Inspection Strip in Tube | | Cut Too Short | | Misread | | Power Loss/Surge | | | | | | |
| Ripples in Bend | | Drill Holes | | Offset | | | | | | | | |
| Torque Waves in Extrusion | | Drawing | | Out of Calibration | | | | | | | | |
| Turning Sequence | | Finish | | Out of Sequence | | | | | | | | |
| Wave/Twist in Tube | | Folio | | Outside Dimensions | | | | | | | | |

Picklist Print

Page 5

October-30-12 8:48:15 AM

Work Order ID: 92463

92463
D350-636-012

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

14.0000

1

1

**

u u z

D3794-1

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP | 2 | |
| 87631 | 2 | |
| FP012 | 12 | |
| <u>90163</u> | 12 | |

NAS1611-010

Purchased No

230

Each

336.0000

8

u u z

NAS1611-010

O-RING

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP | 184 | |
| 110915 | 0 | |
| <u>123348</u> | 184 | |
| FP001 | 152 | |
| 110915 | 14 | |
| 117460 | 8 | |
| 118077 | 1 | |
| 118612 | 3 | |
| 119438 | 39 | |
| 121259 | 2 | |
| 121584 | 2 | |
| 121723 | 7 | |
| 122151 | 8 | |
| 123352 | 68 | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: Part No. NCR No. | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
|------------------------------------|-------|----------------|-------------------|---|-----------|----------------------|--------------------|--------------------|--------------|--------------|
| Rework | Scrap | Use-as-is | Work Order Update | Skid-tube | Crosstube | Water Jet | Engineering | | | |
| | | | | Machining | Small Fab | Prod. Eng. Coor. | Quality | | | |
| | | | | Thermoforming | Finishing | Rec/Store/Packaging | Other | | | |
| | | | | Large Fab | Composite | Supplier | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | |
| Bending | | Bend | | Grain | | Ovalized | | Pressure/Forced | | |
| Centre Not Concentric to O/S | | BOM/Route | | Hardware | | Over/Under tolerance | | Temperature/Cure | | |
| Cracks | | Broken/Damaged | | Inspection Incomplete | | Part Incorrect | | Weld | | |
| Crushed/Crimped | | Burrs | | Instructions Incomplete/Unclear | | Part Lost/Missing | | Wrong Stock Pulled | | |
| Cuffs | | Contamination | | Maintenance | | Part Moved | | | | |
| Heat Treat | | Countersink | | Mislabeled | | Positioned Wrong | | | | |
| Inspection Strip in Tube | | Cut Too Short | | Misread | | Power Loss/Surge | | Other | | |
| Ripples in Bend | | Drill Holes | | Offset | | | | | | |
| Torque Waves in Extrusion | | Drawing | | Out of Calibration | | | | | | |
| Turning Sequence | | Finish | | Out of Sequence | | | | | | |
| Wave/Twist in Tube | | Folio | | Outside Dimensions | | | | | | |

Picklist Print

Page 6

October-30-12 8:48:15 AM

Work Order ID: 92463

92463

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

D2741

Blade, 350 Skidtube

Manufactured

No

250

Each

44.0000



1

**

54

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|-------|----|--|
| FG | 1 | |
| 85480 | 1 | |
| ST466 | 43 | |
| 71856 | 1 | |
| 85480 | 4 | |
| 88824 | 38 | |

NAS1515H3L

Purchased

No

230

Each

167.0000

4

4

**

HL ululz

***NAS1515H3L ***

WASHER

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|--------|-----|--|
| FG | 40 | |
| 102472 | 40 | |
| ST277 | 127 | |
| 118686 | 3 | |
| 120360 | 11 | |
| 121556 | 45 | |
| 122151 | 68 | |

NAS1611-013

Purchased

No

230

Each

128.0000

8

8

**

HL ululz

NAS1611-013

O-RING

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|--------|-----|--|
| FP001 | 128 | |
| 116582 | 5 | |
| 117291 | 2 | |
| 117887 | 53 | |
| 119623 | 36 | |
| 121825 | 10 | |
| 122993 | 22 | |

M123741

V8

NCR: Yes / No

DQA: Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
|---|--------------------------|------|------|--|--|--|--|---|--|-------------|--------------|--|--|---|--|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Equip/Tooling | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Operator | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Material | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Setup | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Other | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Process | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Supplier | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Training | <input type="checkbox"/> | | | | | | | | | | | | | | |
| Unapproved | <input type="checkbox"/> | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |

Picklist Print

Page 7

October-30-12 8:48:15 AM

Work Order ID: 92463

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

92463
D350-636-012

Start Date: 30/10/2012

Start Qty: 1.00

Required Date: 13/11/2012

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

979.0000

4

4

**

M

111121

AN3C6A

BOLT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 10 | |
| 122416 | 10 | |
| FP001 | 1 | |
| 111982 | 1 | |
| ST512 | 968 | |
| 111982 | 2 | |
| 116419 | 23 | |
| 116549 | 2 | |
| 116704 | 12 | |
| 117619 | 10 | |
| 117688 | 1 | |
| 117872 | 5 | |
| 118422 | 13 | |
| 119449 | 21 | |
| 120423 | 3 | |
| 120693 | 34 | |
| 121682 | 4 | |
| 122416 | 338 | |
| <u>122599</u> | 500 | |

NAS1149C0832R

Purchased

No

230

Each

396.0000

1

1

**

M

111121

NAS1149C0832R

WASHER

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| 296 | 200 | |
| 122441 | 200 | |
| ST297 | 196 | |
| <u>114915</u> | 196 | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | | | | | | |
|-------------------|-------------------|--------|-------------|---|----------------------------|---------------------------------|----------------------|--------------------|-----------|-----------|-------------|--------------|--------------|------------------|---------------------|----------|-------------|---------|-------|
| Part No. _____ | Work Order Update | Rework | Scrap | Use-as-is | Skid-tube | Machining | Thermoforming | Large Fab | Crosstube | Small Fab | Finishing | Composite | Water Jet | Prod. Eng. Coor. | Rec/Store/Packaging | Supplier | Engineering | Quality | Other |
| NCR No. _____ | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | | Initial Chief Eng | Action Description | | | Sign & Date | Verification | QC Inspector | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | | | | | | | | | |
| | | | | Bending | Bend | Grain | Ovalized | Pressure/Forced | | | | | | | | | | | |
| | | | | Centre Not Concentric to O/S | BOM/Route | Hardware | Over/Under tolerance | Temperature/Cure | | | | | | | | | | | |
| | | | | Cracks | Broken/Damaged | Inspection Incomplete | Part Incorrect | Weld | | | | | | | | | | | |
| | | | | Crushed/Crimped. | Burrs | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Stock Pulled | | | | | | | | | | | |
| | | | | Cuffs | Contamination | Maintenance | Part Moved | | | | | | | | | | | | |
| | | | | Heat Treat | Countersink | Mislabeled | Positioned Wrong | | | | | | | | | | | | |
| | | | | Inspection Strip in Tube | Cut Too Short | Misread | Power Loss/Surge | Other | | | | | | | | | | | |
| | | | | Ripples in Bend | Drill Holes | Offset | | | | | | | | | | | | | |
| | | | | Torque Waves in Extrusion | Drawing | Out of Calibration | | | | | | | | | | | | | |
| | | | | Turning Sequence | Finish | Out of Sequence | | | | | | | | | | | | | |
| | | | | Wave/Twist in Tube | Folio | Outside Dimensions | | | | | | | | | | | | | |

Picklist Print

Page 8

October-30-12 8:48:15 AM

Work Order ID: 92463

92463
D350-636-012

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

8.0000

1

1

**

M 11121

D3536-25

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 2 | B91814 |
| 87053 | 2 | |
| FP | 1 | |
| 83900 | 1 | |
| FP002 | 5 | |
| 89057 | 1 | |
| 90820 | 4 | |

D3794-3

Manufactured No

230

Each

9.0000

1

1

**

M 11121

D3794-3

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 9 | B91855 |
| 74530 | 2 | |
| 86243 | 7 | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|------|------|--|---|------------------------------------|--|--------------------------------------|--------------------|-------------|--------------|--------------|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| | | | | Bending | Bend | Grain | Ovalized | Pressure/Forced | | | |
| | | | | Centre Not Concentric to O/S | BOM/Route | Hardware | Over/Under tolerance | Temperature/Cure | | | |
| | | | | Cracks | Broken/Damaged | Inspection Incomplete | Part Incorrect | Weld | | | |
| | | | | Crushed/Crimped | Burrs | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Stock Pulled | | | |
| | | | | Cuffs | Contamination | Maintenance | Part Moved | | | | |
| | | | | Heat Treat | Countersink | Mislabeled | Positioned Wrong | | | | |
| | | | | Inspection Strip in Tube | Cut Too Short | Misread | Power Loss/Surge | Other | | | |
| | | | | Ripples in Bend | Drill Holes | Offset | | | | | |
| | | | | Torque Waves in Extrusion | Drawing | Out of Calibration | | | | | |
| | | | | Turning Sequence | Finish | Out of Sequence | | | | | |
| | | | | Wave/Twist in Tube | Folio | Outside Dimensions | | | | | |

Picklist Print

Page 9

October-30-12 8:48:15 AM

Work Order ID: 92463

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

92463
D350-636-012

Start Date: 30/10/2012

Start Qty: 1.00

Required Date: 13/11/2012

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

414.0000

34

34

**

M

111121

AN3C5A

Bolt

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 5 | M123741 |
| 122800 | 5 | Y34 |
| ST512 | 409 | |
| 115835 | 7 | |
| 116419 | 28 | |
| 117343 | 13 | |
| 117764 | 7 | |
| 117872 | 2 | |
| 119749 | 23 | |
| 120423 | 28 | |
| 121255 | 23 | |
| 121708 | 179 | |
| 122141 | 80 | |
| 122800 | 19 | |

D3537-1

Manufactured

No

230

Each

60.0000

3

3

**

M

111121

D3537-1

Wearpad

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 2 | |
| 88562 | 2 | |
| FP001 | 46 | |
| 90197 | 22 | |
| 91668 | 24 | |
| FP002 | 12 | |
| 83254 | 1 | |
| 83255 | 3 | |
| 87697 | 1 | |
| 88562 | 7 | B91645 |
| | | Y3 |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | | | | | | |
|------------------------------|-------------------|----------------|-------------|---|----------------------------|----------------------|-------------------|--------------------|-----------|------------------|-------------|--------------|--------------|--------------------|---------------------|----------|-------------|---------|-------|
| Part No. _____ | Work Order Update | Rework | Scrap | Use-as-is | Skid-tube | Machining | Thermoforming | Large Fab | Crosstube | Small Fab | Finishing | Composite | Water Jet | Prod. Eng. Coor. | Rec/Store/Packaging | Supplier | Engineering | Quality | Other |
| NCR No. _____ | | | | | | | | | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | | Initial Chief Eng | Action Description | | | Sign & Date | Verification | QC Inspector | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | | | | | | | | | |
| Bending | | Bend | | Grain | | Ovalized | | Pressure/Forced | | Temperature/Cure | | Weld | | Wrong Stock Pulled | | Other | | | |
| Centre Not Concentric to O/S | | BOM/Route | | Hardware | | Over/Under tolerance | | | | Part Incorrect | | | | | | | | | |
| Cracks | | Broken/Damaged | | Inspection Incomplete | | Part Lost/Missing | | | | Part Moved | | | | | | | | | |
| Crushed/Crimped | | Burrs | | Instructions Incomplete/Unclear | | Positioned Wrong | | | | Power Loss/Surge | | | | | | | | | |
| Cuffs | | Contamination | | Maintenance | | | | | | | | | | | | | | | |
| Heat Treat | | Countersink | | Mislabeled | | | | | | | | | | | | | | | |
| Inspection Strip in Tube | | Cut Too Short | | Misread | | | | | | | | | | | | | | | |
| Ripples in Bend | | Drill Holes | | Offset | | | | | | | | | | | | | | | |
| Torque Waves in Extrusion | | Drawing | | Out of Calibration | | | | | | | | | | | | | | | |
| Turning Sequence | | Finish | | Out of Sequence | | | | | | | | | | | | | | | |
| Wave/Twist in Tube | | Folio | | Outside Dimensions | | | | | | | | | | | | | | | |

Picklist Print

Page 10

October-30-12 8:48:15 AM

Work Order ID: 92463

92463
D350-636-012

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

17.0000

1

1

**

M ululz

D3535-25

Wearshoe

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP001 | 17 | |
| 62233 | 1 | |
| 81357 | 1 | |
| 87385 | 6 | |
| <u>90061</u> | 9 | |

D3492-3

Manufactured No

230

Each

155.0000

8

8

**

M ululz

D3492-3

Plug

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP001 | 40 | |
| <u>90322</u> | 40 | |
| FP002 | 40 | |
| 89291 | 40 | |
| FP-A | 75 | |
| 81967 | 5 | |
| 83099 | 3 | |
| 83529 | 4 | |
| 85461 | 1 | |
| 86865 | 2 | |
| 91610 | 60 | |

AN960C10L

NAS1149C0332

R

Purchased

No

230

Each

21.0000

38

38

**

M ululz

***AN960C10L ***

washer

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST | 21 | |
| 107534 | 21 | |
| | | X30 |
| | | 11123355 |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|---|--|--|---|--|--------------------------------------|-------------|--------------|--------------|
| Part No. _____ | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| NCR No. _____ | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unapproved | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | |
| Landing Gear | General | | | | | | | | |
| | Bending <input type="checkbox"/> | Bend <input type="checkbox"/> | Grain <input type="checkbox"/> | Ovalized <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | | | | |
| | Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Hardware <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | | | | |
| | Cracks <input type="checkbox"/> | Broken/Damaged <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Weld <input type="checkbox"/> | | | | |
| | Crushed/Crimped <input type="checkbox"/> | Burrs <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | | | | |
| | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Maintenance <input type="checkbox"/> | Part Moved <input type="checkbox"/> | | | | | |
| | Heat Treat <input type="checkbox"/> | Countersink <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | | | | | |
| | Inspection Strip in Tube <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Misread <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | Ripples in Bend <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Offset <input type="checkbox"/> | | | | | | |
| | Torque Waves in Extrusion <input type="checkbox"/> | Drawing <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | | | | | | |
| | Turning Sequence <input type="checkbox"/> | Finish <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | | | | | | |
| | Wave/Twist in Tube <input type="checkbox"/> | Folio <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | | | | | | |

Picklist Print

Page 11

October-30-12 8:48:15 AM

Work Order ID: 92463

92463

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230

Each

7.0000

1

1

**

u

u/u/z

D3488-042

Blade Fitting Assembly, RH

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|-------|---|--|
| FP002 | 7 | |
| 83417 | 2 | |
| 85734 | 3 | |
| 86054 | 2 | |

ALS4-1032-225

Purchased No

230

Each

2,201.000

38

38

**

u

u/u/z

A1 S4-1032-225

Insert

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
|----------|---------|----------|

| | | |
|--------|-----|--|
| FP-B | 770 | |
| 122290 | 770 | |

| | | |
|-------|------|--|
| ST281 | 1408 | |
|-------|------|--|

| | | |
|--------|-----|--|
| 108696 | 146 | |
|--------|-----|--|

| | | |
|--------|----|--|
| 110768 | 62 | |
|--------|----|--|

| | | |
|--------|----|--|
| 118386 | 55 | |
|--------|----|--|

| | | |
|--------|----|--|
| 118966 | 68 | |
|--------|----|--|

| | | |
|--------|----|--|
| 121269 | 77 | |
|--------|----|--|

| | | |
|--------|------|--|
| 122827 | 1000 | |
|--------|------|--|

| | | |
|-------|----|--|
| ST282 | 23 | |
|-------|----|--|

| | | |
|--------|----|--|
| 120410 | 10 | |
|--------|----|--|

| | | |
|--------|----|--|
| 120451 | 13 | |
|--------|----|--|

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|------------------------------|--|--|------------------------------------|---|------------------------------------|--------------------------------------|-------------|--------------|--------------|--|--|
| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No. _____ | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | |
| NCR No. _____ | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | |
| | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| Bending | Bend | Grain | Ovalized | Pressure/Forced | | | | | | | |
| Centre Not Concentric to O/S | BOM/Route | Hardware | Over/Under tolerance | Temperature/Cure | | | | | | | |
| Cracks | Broken/Damaged | Inspection Incomplete | Part Incorrect | Weld | | | | | | | |
| Crushed/Crimped. | Burrs | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Stock Pulled | | | | | | | |
| Cuffs | Contamination | Maintenance | Part Moved | | | | | | | | |
| Heat Treat | Countersink | Mislabeled | Positioned Wrong | | | | | | | | |
| Inspection Strip in Tube | Cut Too Short | Misread | Power Loss/Surge | Other | | | | | | | |
| Ripples in Bend | Drill Holes | Offset | | | | | | | | | |
| Torque Waves in Extrusion | Drawing | Out of Calibration | | | | | | | | | |
| Turning Sequence | Finish | Out of Sequence | | | | | | | | | |
| Wave/Twist in Tube | Folio | Outside Dimensions | | | | | | | | | |

Picklist Print

Page 12

October-30-12 8:48:15 AM

Work Order ID: 92463

92463
D350-636-012

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

114.0000

8

8

**

D3492-1

Plug

Jul 11/12

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 18 | |
| 69531 | 8 | |
| 74444 | 2 | |
| 76235 | 4 | |
| 88541 | 3 | |
| <u>89363</u> | 1 | |
| FP-A | 96 | |
| 83098 | 7 | |
| <u>91466</u> | 89 | |

D3793-1

Manufactured No

230

Each

15.0000

1

1

**

D3793-1

Wearshoe

Jul 11/12

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 15 | |
| 82171 | 2 | |
| 87273 | 3 | |
| <u>89999</u> | 10 | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | | | AGAINST DEPARTMENT/PROCESS | | | | | | |
|-------------------|------------------------------|----------------|-------|---|-------------------|----------------------------|----------------------|---------------------|--------------------|--------------|--------------|--|
| Part No. _____ | | Rework | Scrap | Use-as-is | Work Order Update | Skid-tube | Crosstube | Water Jet | Engineering | | | |
| NCR No. _____ | | | | | | Machining | Small Fab | Prod. Eng. Coor. | Quality | | | |
| | | | | | | Thermoforming | Finishing | Rec/Store/Packaging | Other | | | |
| | | | | | | Large Fab | Composite | Supplier | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear | General | | | | | | | | | | | |
| | Bending | Bend | | Grain | | | Ovalized | | Pressure/Forced | | | |
| | Centre Not Concentric to O/S | BOM/Route | | Hardware | | | Over/Under tolerance | | Temperature/Cure | | | |
| | Cracks | Broken/Damaged | | Inspection Incomplete | | | Part Incorrect | | Weld | | | |
| | Crushed/Crimped | Burrs | | Instructions Incomplete/Unclear | | | Part Lost/Missing | | Wrong Stock Pulled | | | |
| | Cuffs | Contamination | | Maintenance | | | Part Moved | | | | | |
| | Heat Treat | Countersink | | Mislabeled | | | Positioned Wrong | | | | | |
| | Inspection Strip in Tube | Cut Too Short | | Misread | | | Power Loss/Surge | | | | | |
| | Ripples in Bend | Drill Holes | | Offset | | | | | | | | |
| | Torque Waves in Extrusion | Drawing | | Out of Calibration | | | | | | | | |
| | Turning Sequence | Finish | | Out of Sequence | | | | | | | | |
| | Wave/Twist in Tube | Folio | | Outside Dimensions | | | | | | | | |

Picklist Print

Page 13

October-30-12 8:48:15 AM

Work Order ID: 92463

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

92463
D350-636-012

Start Date: 30/10/2012

Start Qty: 1.00

Required Date: 13/11/2012

Required Qty: 1.00

AN8C35A

Purchased No

230 Each 15.0000

1

**

AN8C35A

BOLT

sl uulz

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-------|--------|-----------|
| FG | 5 | 111236412 |
| | 5 | |
| FP002 | 9 | |
| | 115960 | |
| | 121275 | |
| ST346 | 1 | |
| | 114442 | |
| | 115188 | |
| | 115960 | |

MS21083C8

Purchased No

230 Each 50.0000

1

**

MS21083C8

NUT

sl uulz

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

| | | |
|-------|--------|--|
| 318 | 2 | |
| | 122452 | |
| FP002 | 1 | |
| | 115884 | |
| ST303 | 4 | |
| | 115884 | |
| | 118077 | |
| | 119309 | |
| | 119638 | |
| ST319 | 38 | |
| | 123346 | |
| ST321 | 5 | |
| | 122141 | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|---|------|------|--|--|------------------------------------|--|--------------------------------------|--------------|--------------|--|
| Part No. _____ | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| NCR No. _____ | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | |
| | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | | | | |
| | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | | | | |

Picklist Print

October-30-12 8:48:15 AM

Page 14

Work Order ID: 92463

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

92463
D350-636-012

Start Date: 30/10/2012

Start Qty: 1.00

Required Date: 13/11/2012

Required Qty: 1.00

D2745

Manufactured No

230

Each

30.0000

8

8

**

*u u u u****D2745***

Bushing

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|--------------------------|
| FP | 26 | <i>392539</i> <i>x 8</i> |
| 79518 | 6 | _____ |
| 87527 | 4 | _____ |
| 89303 | 16 | _____ |
| FP001 | 4 | _____ |
| 69529 | 1 | _____ |
| 76142 | 1 | _____ |
| 83260 | 2 | _____ |

AN6C44A

Purchased No

230

Each

58.0000

4

4

**

*u u u u****AN6C44A***

BOLT

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 2 | _____ |
| 103964 | 2 | _____ |
| ST340 | 38 | _____ |
| <u>122491</u> | 38 | <i>x 4</i> |
| ST341 | 4 | _____ |
| 122843 | 4 | _____ |
| ST343 | 14 | _____ |
| 121013 | 11 | _____ |
| 121167 | 2 | _____ |
| 122204 | 1 | _____ |

NCR: Yes / No

DQA: Date: .

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
|---|--|------|------|--|--|--|--|---|--|-------------|--------------|--|--|---|--|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube | | | | General Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> | | | | Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> | | | | Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> | | Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/> | |

Picklist Print

Page 15

October-30-12 8:48:15 AM

Work Order ID: 92463

92463

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

D3532-1

Spacer

Manufactured No

250

Each

20.0000

3
**
2

20

2

Location

Loc Qty

Loc Code

ST055

20

85484

8

91324

12

91324

MS21083C8

MS21083C8

NUT

Purchased No

250

Each

50.0000

2
**
2

20

12/11/23

Location

Loc Qty

Loc Code

318

2

122452

2

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST319

38

123346

38

ST321

5

122141

5

123346

NCR: Yes / No

DQA: Date: ▼

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | |
|--|--|------|------|---|--|--|--|---|--|-------------|--------------|--|--|---|--|
| | | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |

Picklist Print

October-30-12 8:48:15 AM

Work Order ID: 92463

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

92463
D350-636-012

Start Date: 30/10/2012

Start Qty: 1.00

2 2

**

Required Date: 13/11/2012

Required Qty: 1.00

2 2

30

NAS1149D0863J

Purchased

No

250

Each

129.0000

NAS1149D0863J
WASHER

SmB

Location Loc Qty Loc Code

| | | |
|---------------|-----|-----------------|
| ST298 | 129 | |
| 118078 | 18 | |
| 119307 | 1 | |
| <u>120308</u> | 10 | <u>1x120308</u> |
| <u>121556</u> | 100 | <u>1x121556</u> |

D3493-1

Manufactured

No

250

Each 5.0000

**

D3493-1

Washer

SmB

Location Loc Qty Loc Code

| | | |
|-------|---|--|
| ST052 | 5 | |
| 77573 | 1 | |
| 82023 | 2 | |
| 83097 | 2 | |

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

AN8C21A

Purchased

No

250

Each 6.0000

**

AN8C21A

BOLT

SmB

Location Loc Qty Loc Code

| | | |
|--------|---|--|
| ST341 | 5 | |
| 122519 | 5 | |
| ST343 | 1 | |
| 118758 | 1 | |

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|------|-------------|-------|---|----------------------------|---------------------------------|----------------------|---------------------|--------------|--------------|
| Part No. _____ | | Rework | Scrap | Use-as-is | Work Order Update | Skid-tube | Crosstube | Water Jet | Engineering | |
| NCR No. _____ | | | | | | Machining | Small Fab | Prod. Eng. Coor. | Quality | |
| | | | | | | Thermoforming | Finishing | Rec/Store/Packaging | Other | |
| | | | | | | Large Fab | Composite | Supplier | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | |
| | | | | Bending | Bend | Grain | Ovalized | Pressure/Forced | | |
| | | | | Centre Not Concentric to O/S | BOM/Route | Hardware | Over/Under tolerance | Temperature/Cure | | |
| | | | | Cracks | Broken/Damaged | Inspection Incomplete | Part Incorrect | Weld | | |
| | | | | Crushed/Crimped. | Burrs | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Stock Pulled | | |
| | | | | Cuffs | Contamination | Maintenance | Part Moved | | | |
| | | | | Heat Treat | Countersink | Mislabeled | Positioned Wrong | | | |
| | | | | Inspection Strip in Tube | Cut Too Short | Misread | Power Loss/Surge | Other | | |
| | | | | Ripples in Bend | Drill Holes | Offset | | | | |
| | | | | Torque Waves in Extrusion | Drawing | Out of Calibration | | | | |
| | | | | Turning Sequence | Finish | Out of Sequence | | | | |
| | | | | Wave/Twist in Tube | Folio | Outside Dimensions | | | | |

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|---|
| X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| X | | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| X | | | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| X | | | | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| 1 | | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | 1 | | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | 1 | | | D3488-041 | BLADE FITTING, LH |
| 1 | 1 | | | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | 4 | 4 | | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | 8 | 8 | | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AK54-1032-225, AELS-1032-225) |
| 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

92463 MC5
12-10-30

RELEASED
6-27-22 NAD

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: D2750-041/042/043/044 = 26.5 LBS
- 9) WELD PER DART QSI 004
- 10) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL 
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL 

| DESIGN | RE | DART AEROSPACE USA, INC. | |
|------------|----|--------------------------|---|
| DRAWN | RE | PORT HADLOCK, WA | |
| CHECKED | RE | DRAWING NO. | REV. F |
| MFG. APPR. | RE | D2750 | SHEET 1 OF 11 |
| APPROVED | RE | TITLE | SCALE |
| DE APPR. | RE | 350 SKIDTUBE ASSEMBLY | NTS |
| DATE | RE | 08.07.16 | COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |
| | | | |

8

7

6

5

4

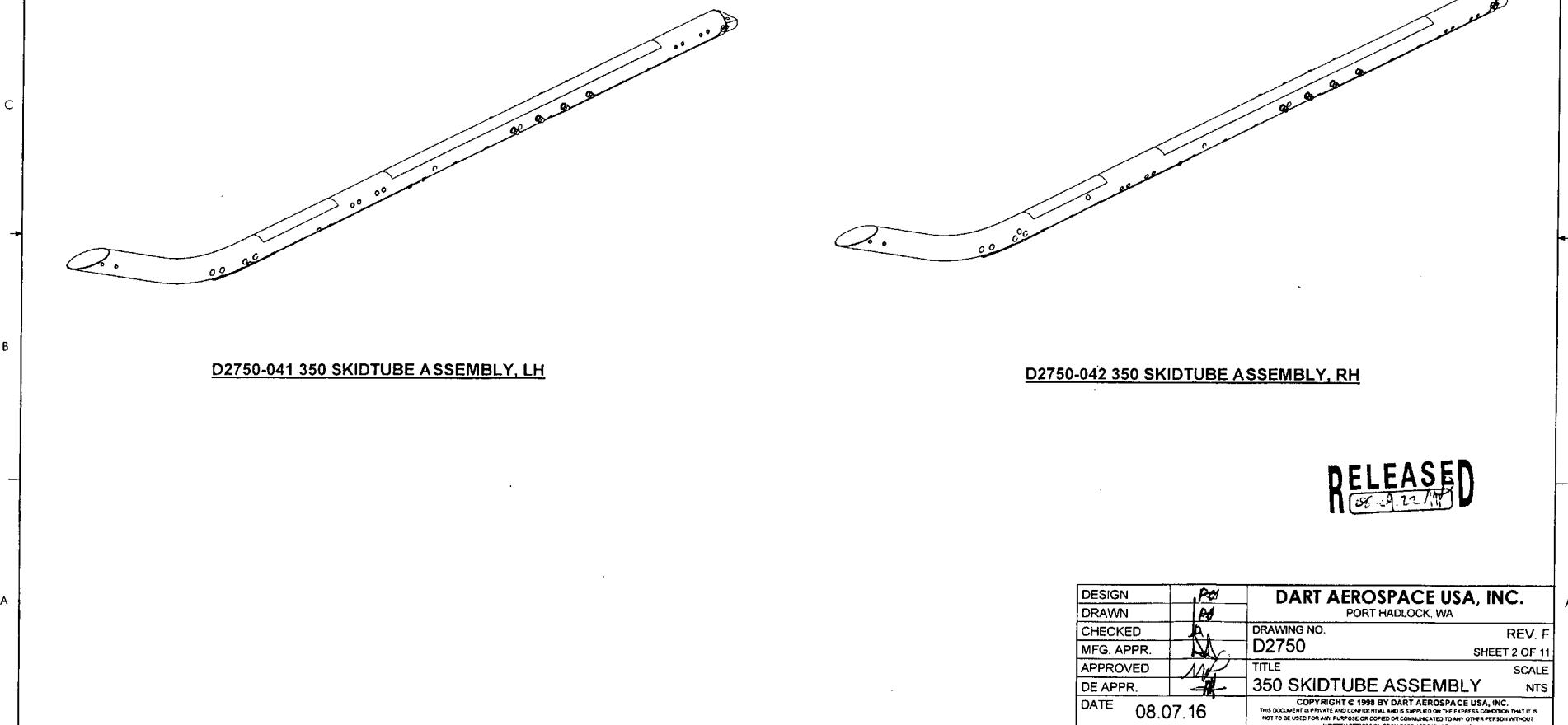
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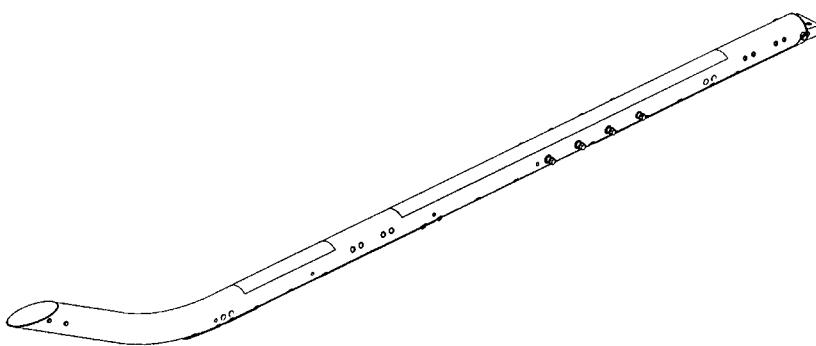
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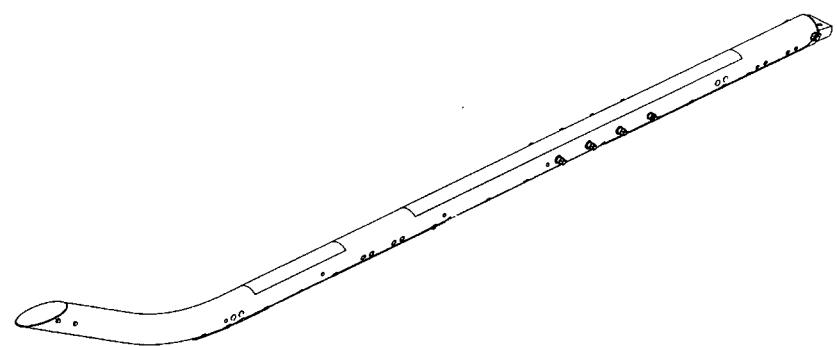
92463



92463



D2750-043 350 SKIDTUBE ASSEMBLY, LH

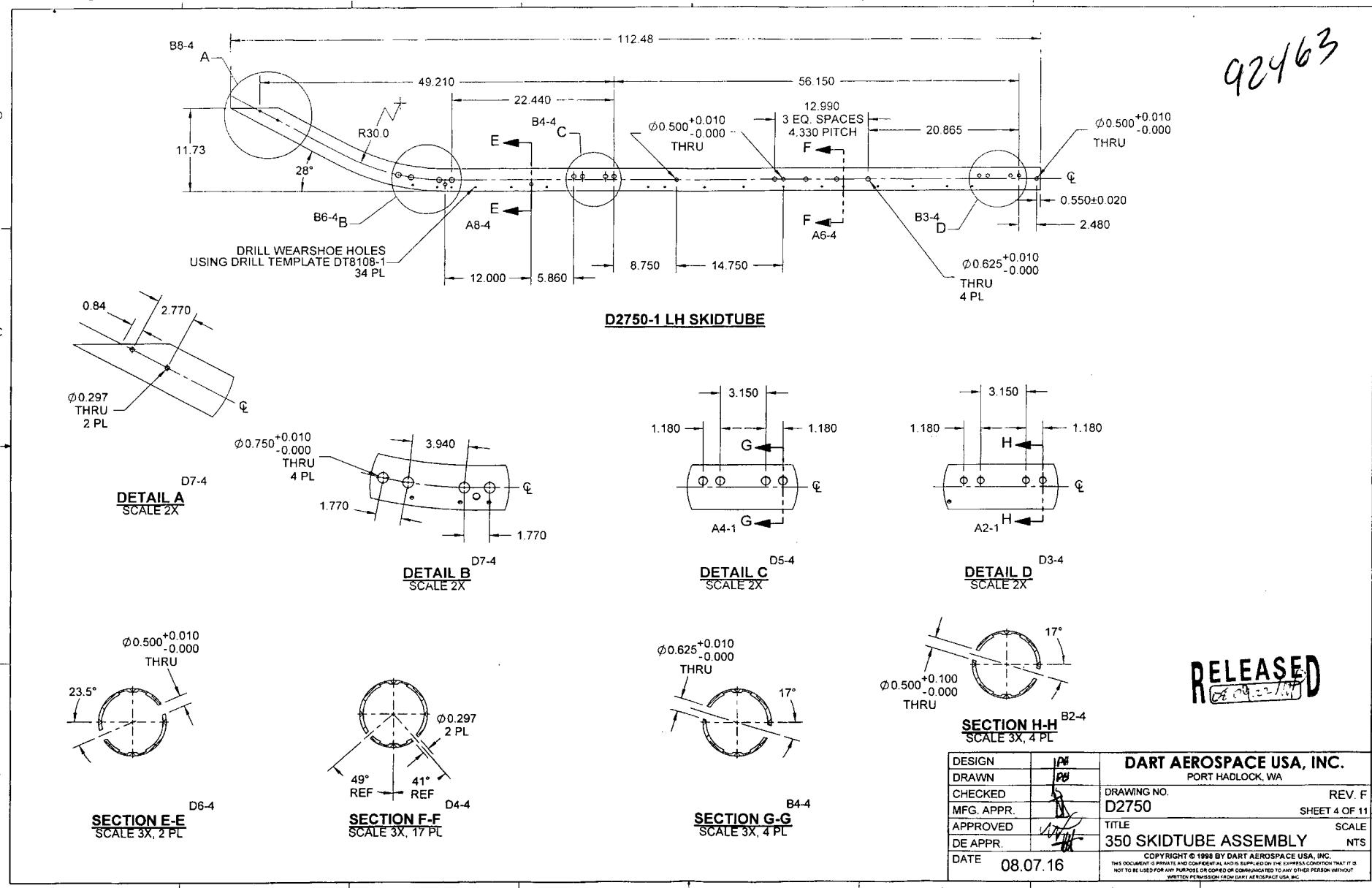


D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
64-9-221M

| | | |
|------------|-----------|---------------------------------|
| DESIGN | <i>Pd</i> | DART AEROSPACE USA, INC. |
| DRAWN | <i>Pd</i> | PORT HADLOCK, WA |
| CHECKED | <i>A</i> | DRAWING NO. |
| MFG. APPR. | <i>AA</i> | D2750 |
| APPROVED | <i>AA</i> | REV. F |
| DE APPR. | <i>AA</i> | SHEET 3 OF 11 |
| DATE | 08.07.16 | TITLE |
| | | 350 SKIDTUBE ASSEMBLY |
| | | NTS |

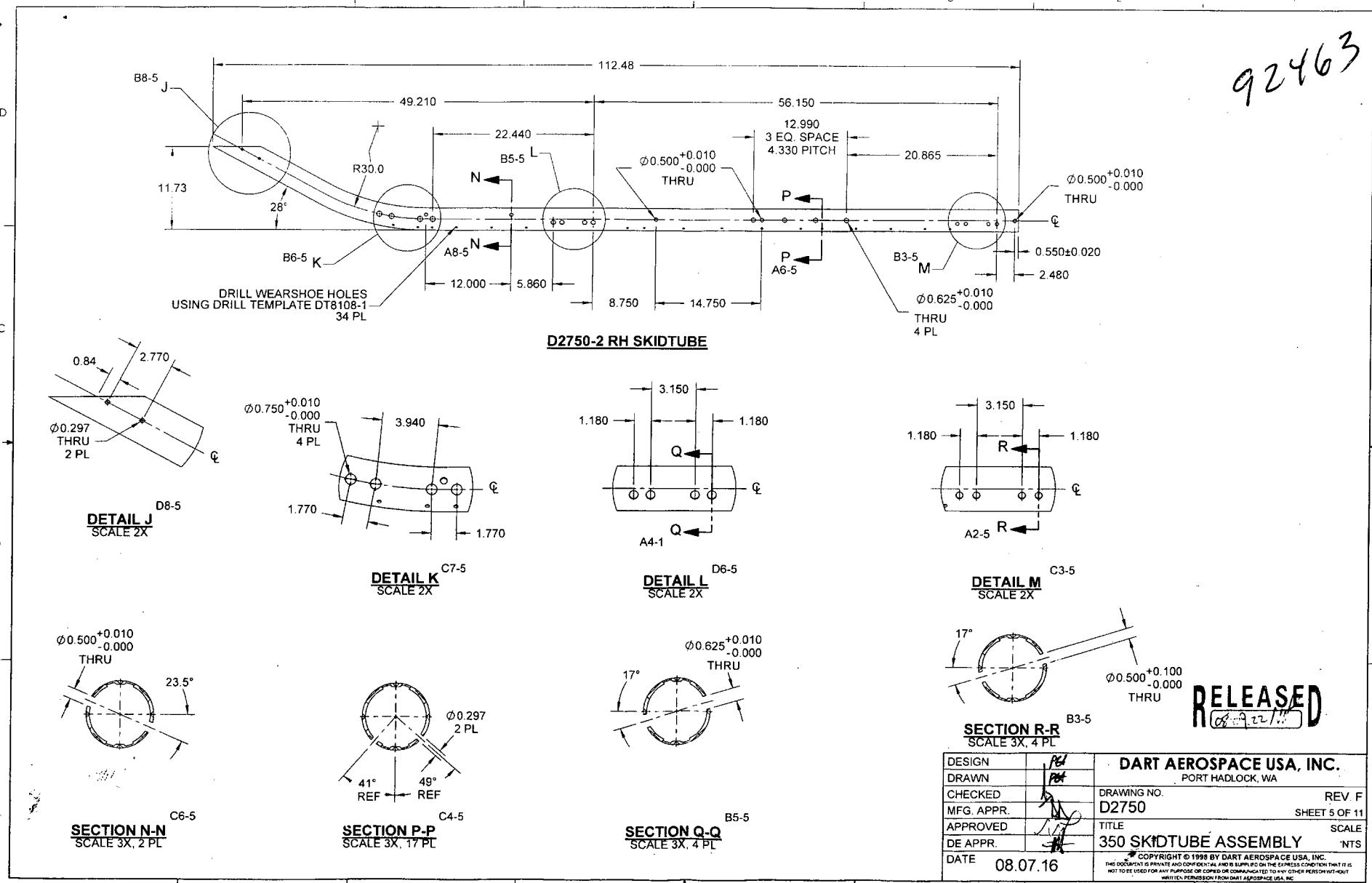
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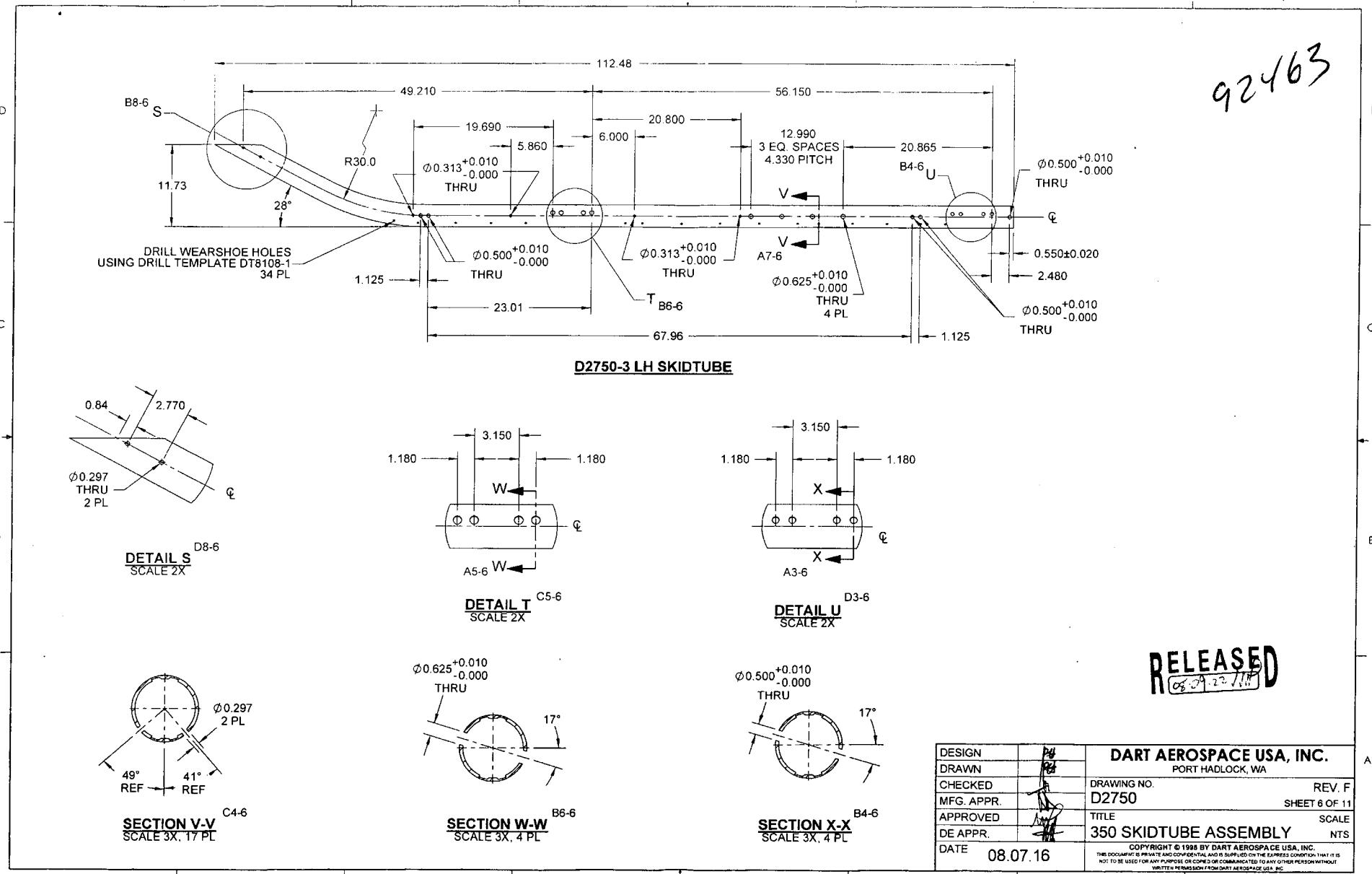
| | | |
|------------|----------|--------------------------|
| DESIGN | IP | DART AEROSPACE USA, INC. |
| DRAWN | IP | PORT HADLOCK, WA |
| CHECKED | | REV. F |
| MFG. APPR. | | DRAWING NO. D2750 |
| APPROVED | | REVISION SHEET 4 OF 11 |
| DE APPR. | | TITLE |
| DATE | 08.07.16 | SCALE |
| | | 350 SKIDTUBE ASSEMBLY |
| | | NTS |

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92463



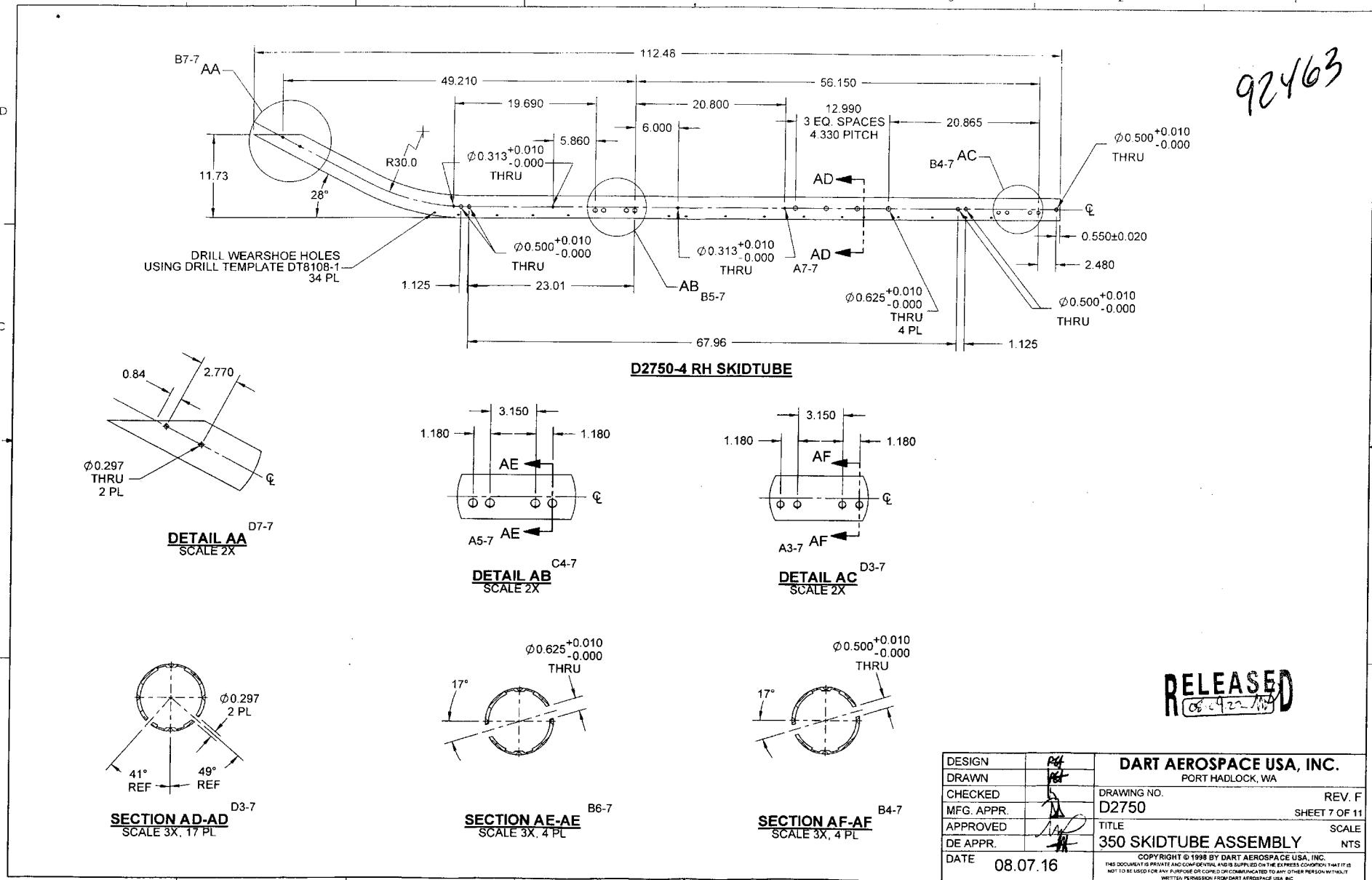
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|------------|----------|--|--|
| DESIGN | PEI | DART AEROSPACE USA, INC. | |
| DRAWN | PAK | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. REV. F | |
| MFG. APPR. | | D2750 SHEET 5 OF 11 | |
| APPROVED | LJF | TITLE SCALE | |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY *NTS* | |
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| | | |
|------------|----------|--------------------------|
| DESIGN | 14 | DART AEROSPACE USA, INC. |
| DRAWN | 14 | PORT HADLOCK, WA |
| CHECKED | 14 | DRAWING NO. D2750 |
| MFG. APPR. | 14 | REV. F |
| APPROVED | 14 | SHEET 6 OF 11 |
| DE APPR. | 14 | TITLE |
| DATE | 08.07.16 | SCALE NTS |

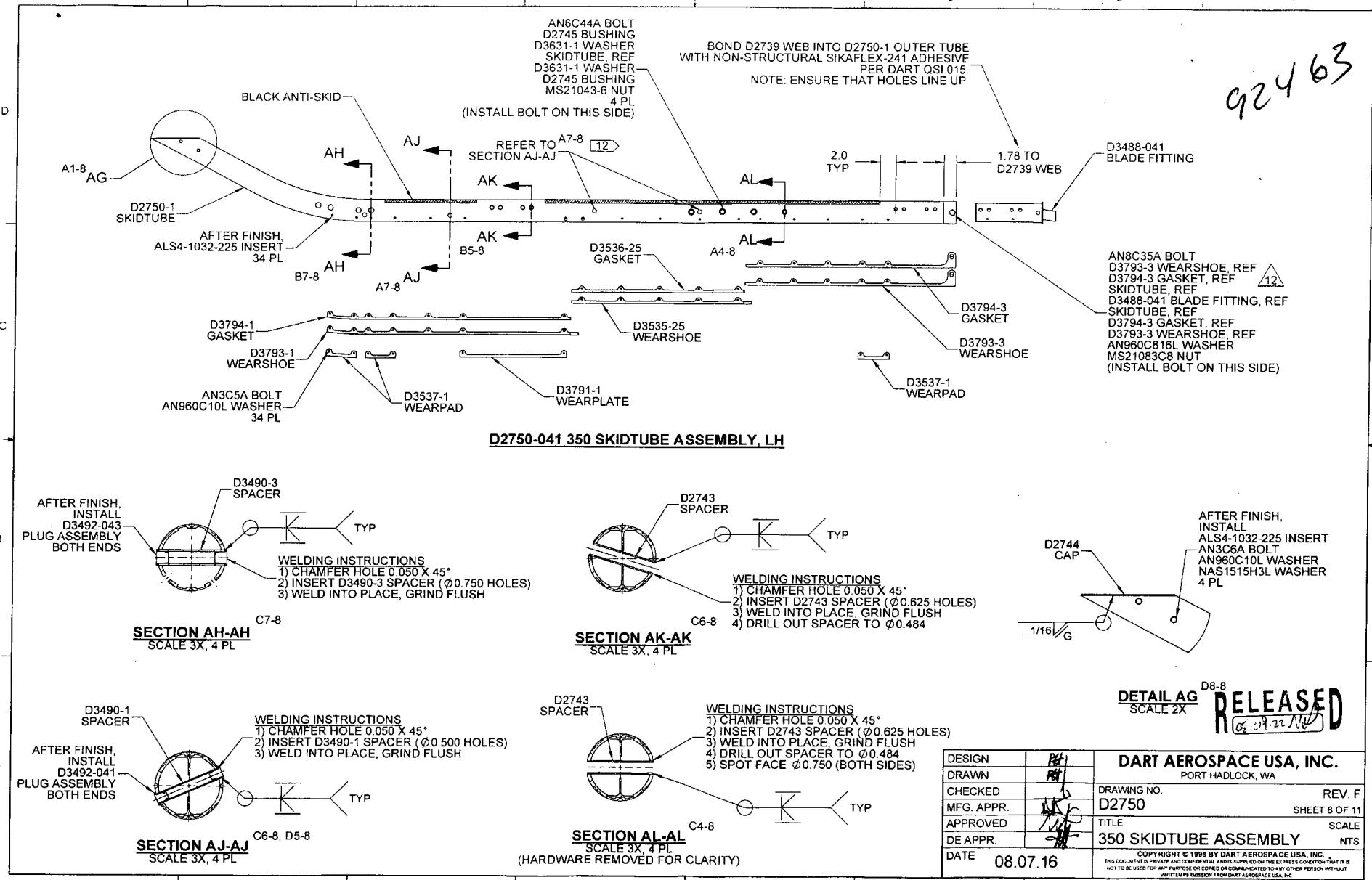
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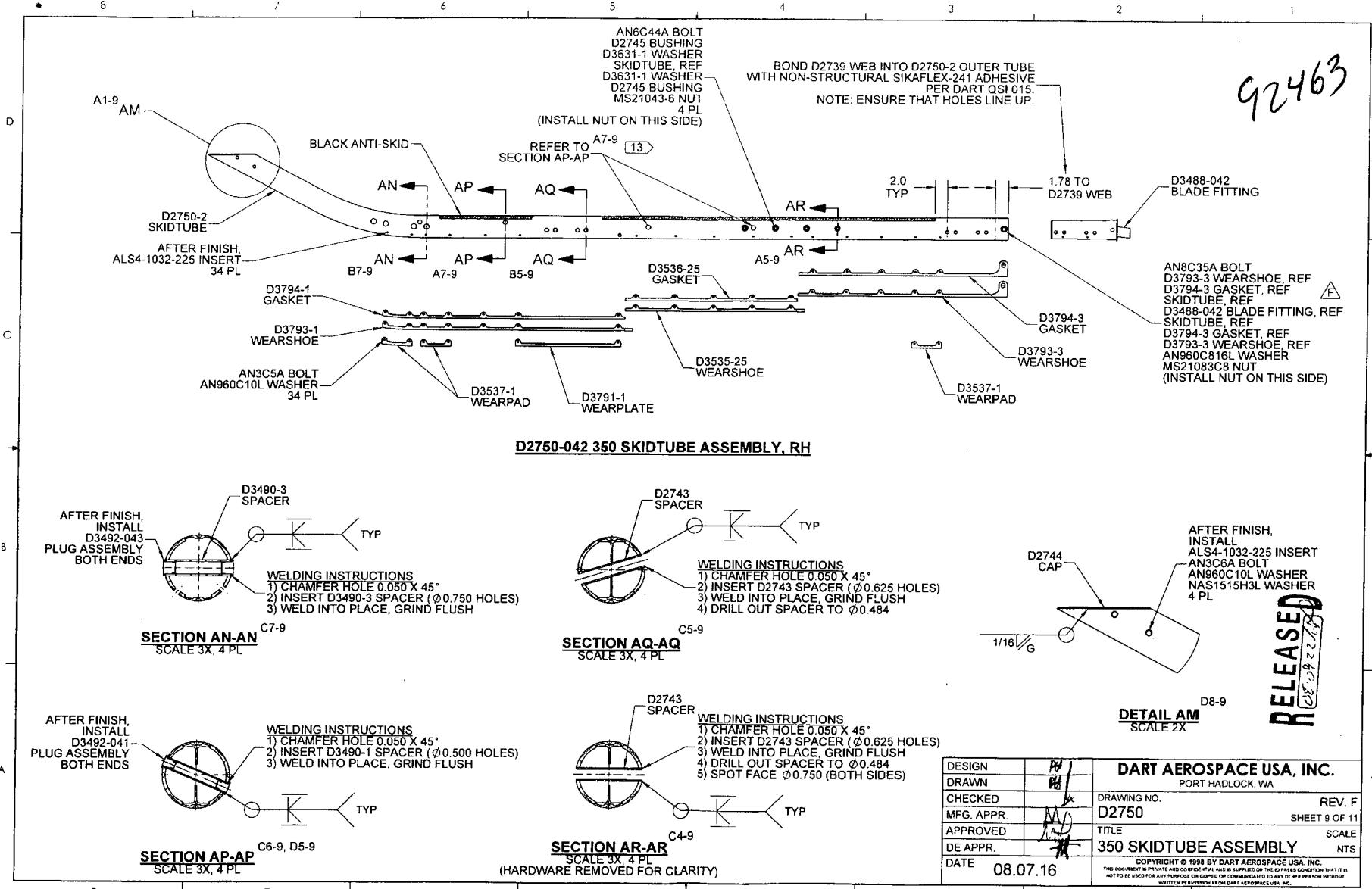
RELEASED
08.07.16

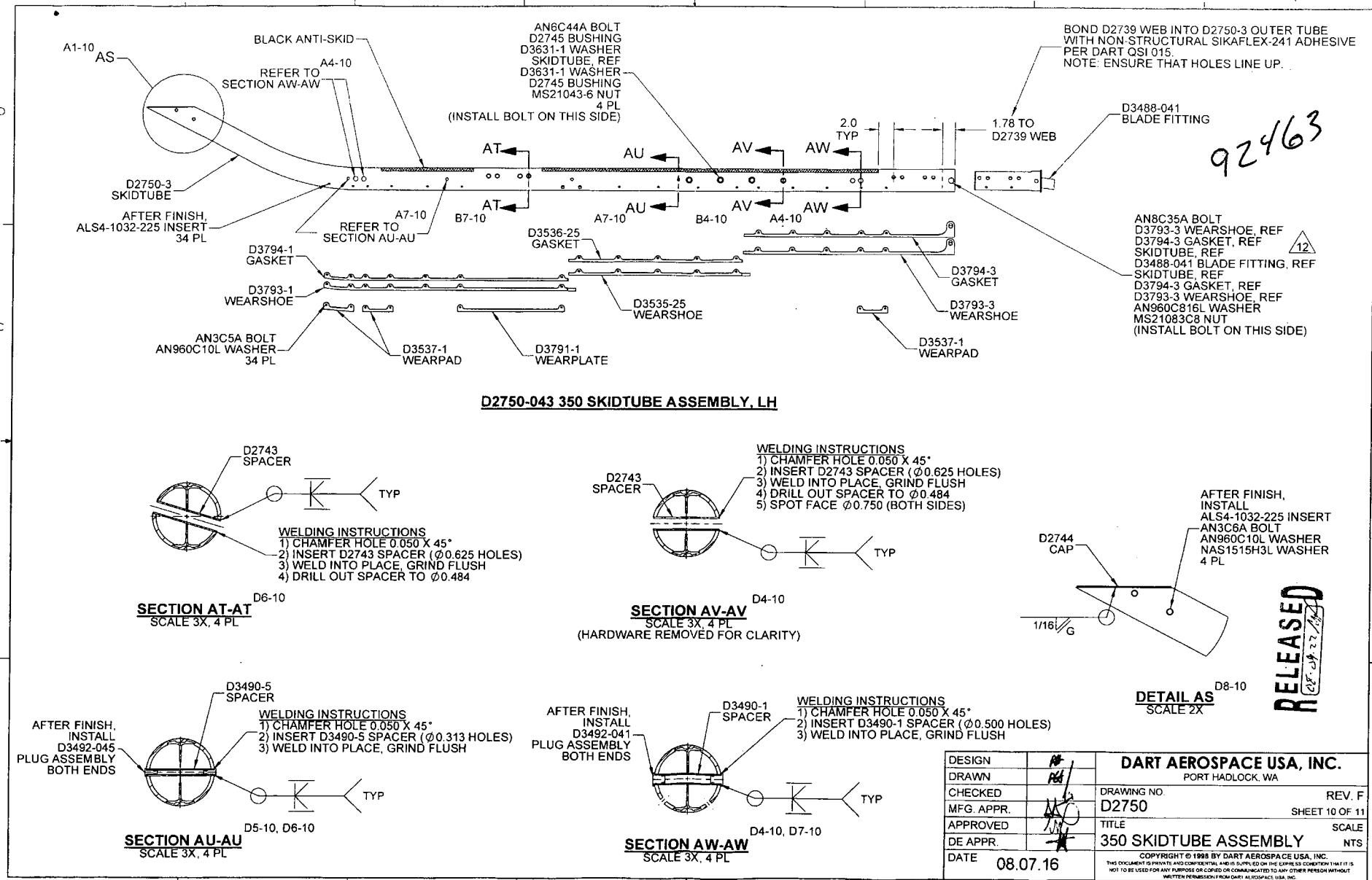


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| DESIGN | RE | DART AEROSPACE USA, INC. |
| DRAWN | RE | PORT HADLOCK, WA |
| CHECKED | | |
| MFG. APPR. | MA | DRAWING NO. D2750 |
| APPROVED | MA | REV. F |
| DE APPR. | MA | SHEET 7 OF 11 |
| DATE | 08.07.16 | TITLE |
| | | 350 SKIDTUBE ASSEMBLY |
| | | SCALE NTS |
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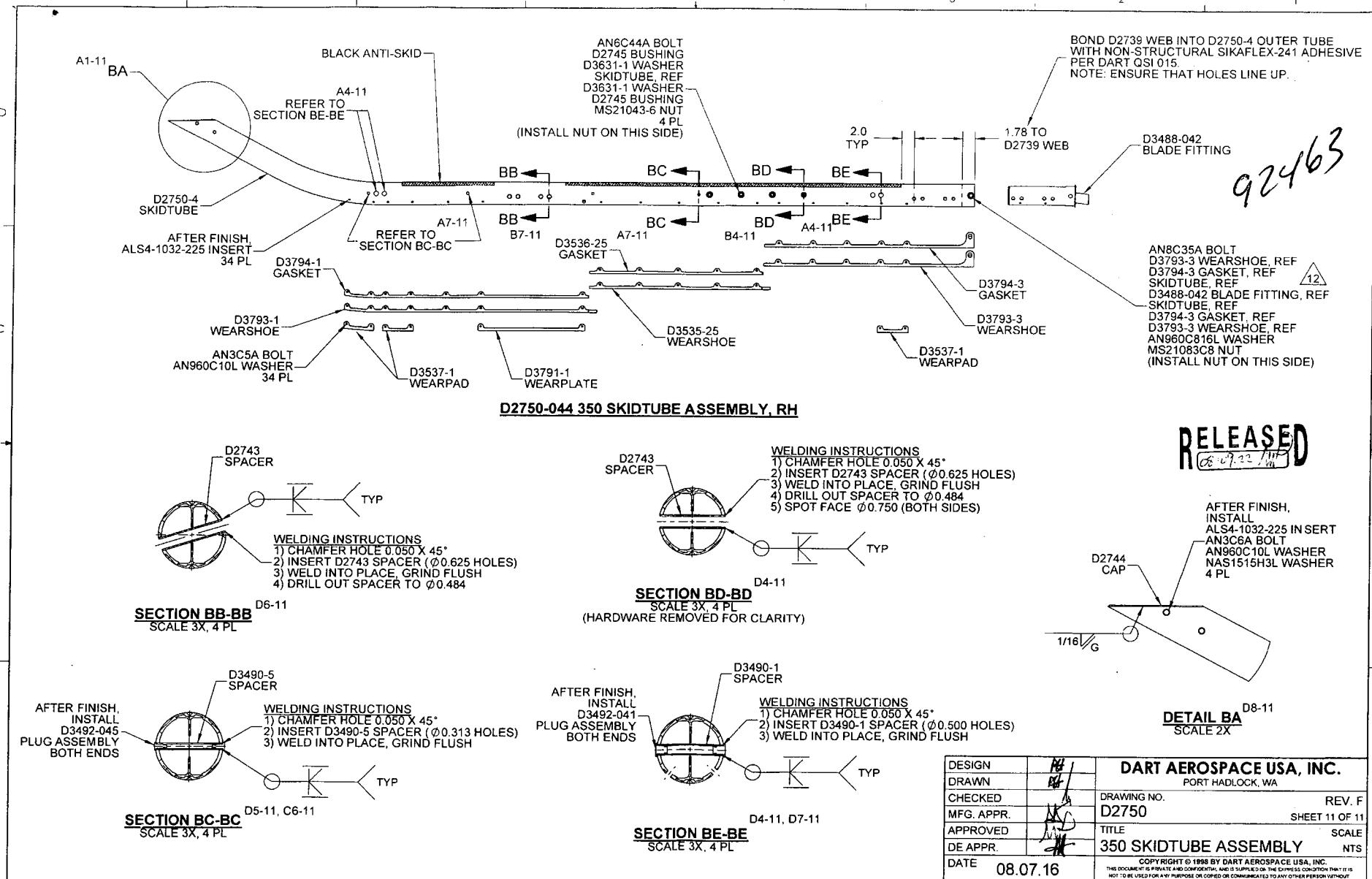




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| DESIGN | <u>10</u> | DART AEROSPACE USA, INC. | | |
| DRAWN | <u>10</u> | PORT HADLOCK, WA | | |
| CHECKED | | DRAWING NO. | REV. F | |
| MFG. APPR. | <u>10</u> | D2750 | SHEET 10 OF 11 | |
| APPROVED | <u>10</u> | TITLE | SCALE | |
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| DESIGN | <i>M</i> | |
| DRAWN | <i>M</i> | |
| CHECKED | <i>M</i> | |
| MFG. APPR. | <i>M</i> | |
| APPROVED | <i>M</i> | |
| DE APPR. | <i>M</i> | |
| DRAWING NO. | D2750 | |
| REV. F | | |
| TITLE | 350 SKIDTUBE ASSEMBLY | SCALE |
| | | NTS |
| DATE | 08.07.16 | |

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NO. 306

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job #: 90946
Part #: D350-636-011
Description: skid tube
Welding Process: Tig Mig
Base material: Aluminum
Current: AC DC

TEST REQUIREMENTS AND RESULTS

| | | |
|-------------------------|--|-------------------------------|
| Visual: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Incomplete Penetration: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Incomplete Fusion: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Cracks: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Overlap (cold lap) | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Undercut: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Pin holes: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Porosity (surface): | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Coloration: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |
| Burn through: | pass <input checked="" type="checkbox"/> | fail <input type="checkbox"/> |

Qualifier J. D. Date of Test Coupon 12-10-12

Welder Barclay Elliott Date of Test Coupon 12-10-12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld